

SHIP 12/12

Dart Aerospace Ltd.

21/10/2008 10:43:35 AM

Process Sheet

U-DAR001 Dart Helicopters Services Drawing Name : N1 GEARBOX ACCESS PANEL KIT
: 42761
Part Number : D3255042
Material Number : 12504
Drawing Number : D3255 REV B
P.O. Number :
Project Number : N/A
This Issue : 21/10/2008 S.O. No. :
Drawing Revision : B
Prsht Rev. : NC
First Issue : / / Type : LARGE FAB ASSY
Drawing Revision : B
Previous Run : 42470
Material :
Written By : Due Date : 15/11/2008 Qty: 4 Um: Each
Checked & Approved By : JLM 08.10.21
Comment : Est Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02
JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32552 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓

Panel

Batch: B 40940

SY 08/12/04

2.0 D32553 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓

Cap

Batch: B 42489

SY 08/12/04

(4)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3255 ***purge weld***

A/R SS ROD Batch: M 108475

2-Grind Welds Flush

SY 08/12/08

(4)

4.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

SY 08/12/08 (4)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SY 08/12/08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/10/2008 10:43:35 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 42761

Part Number: D3255042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M109648



(4X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50
320 OF
2:20

M 08/12/08

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



42



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-08

(X4)

8.0

D32555

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Gasket

Batch: B 42490

FF 08/12/09

(4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg D3255

A/R 736

DOW CORNING ADHESIVE Batch: M 105846

FF 08/12/12

(4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



08-12-12



Comment: INSPECT WORK TO CURRENT STEP

11.0

PACKAGING 1

PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 184

8/12/12

54

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/12

Job Completion



MF 08-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

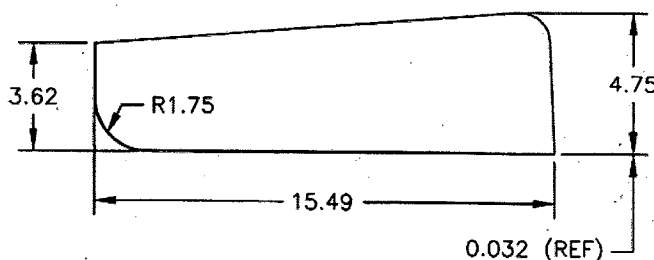
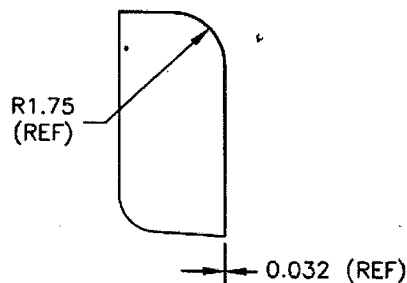
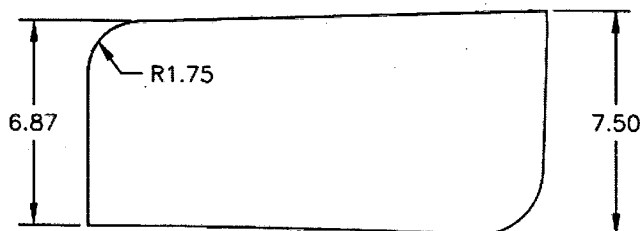
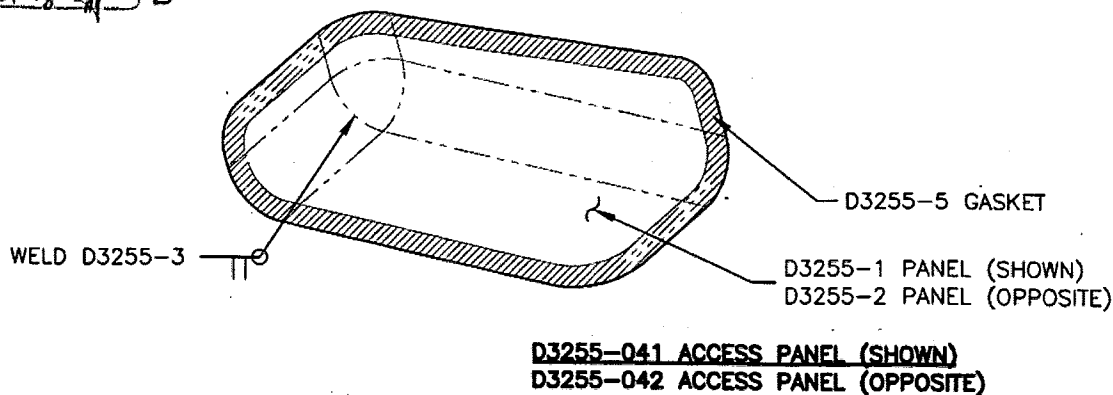
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN F#	DRAWN BY F#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 42761

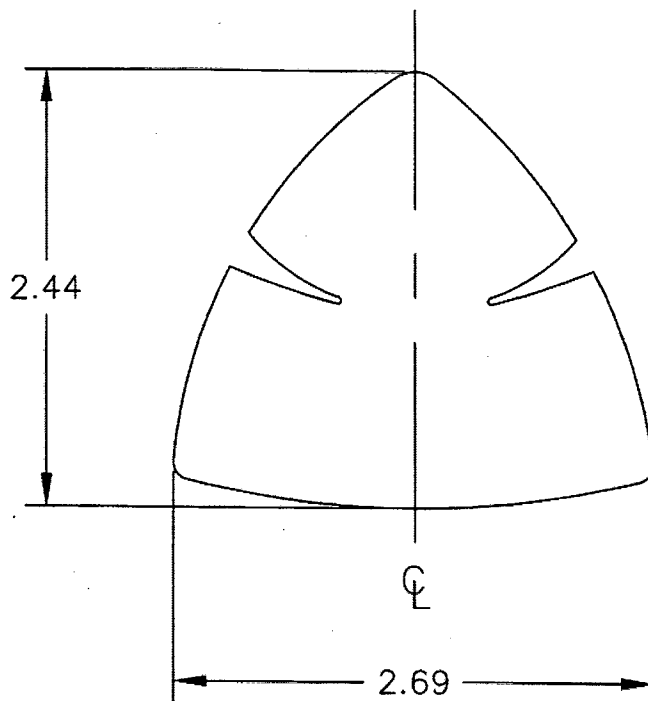
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CHECKED CP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-18 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

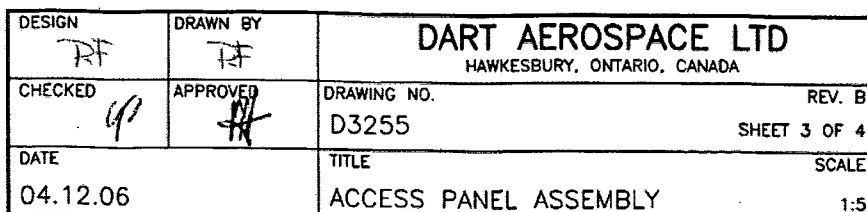
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- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

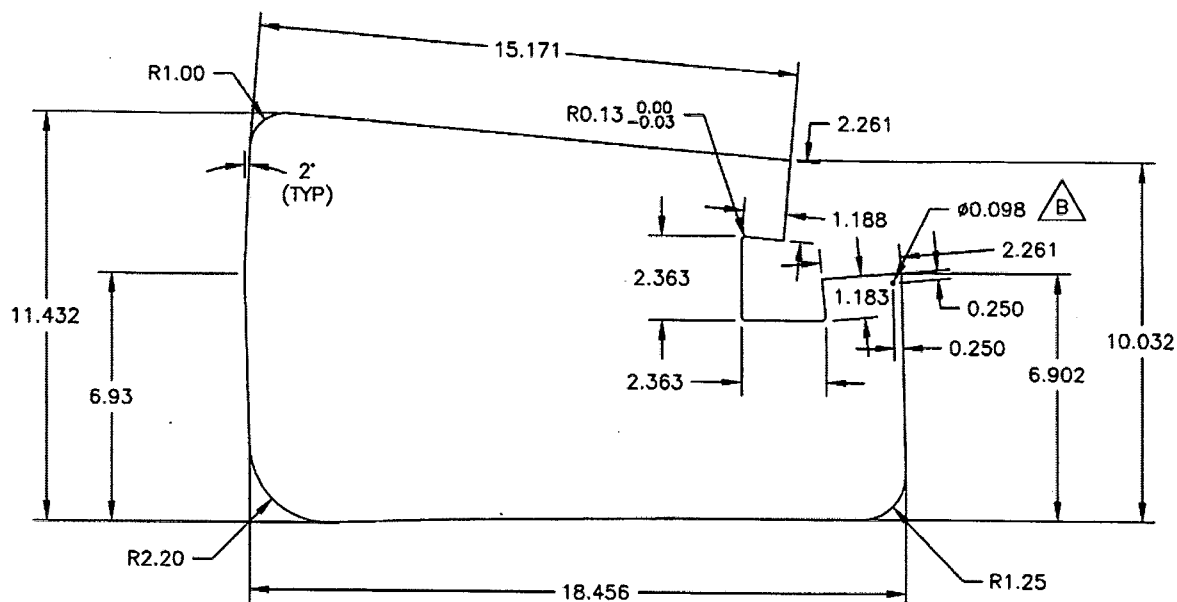
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05-01-18 #



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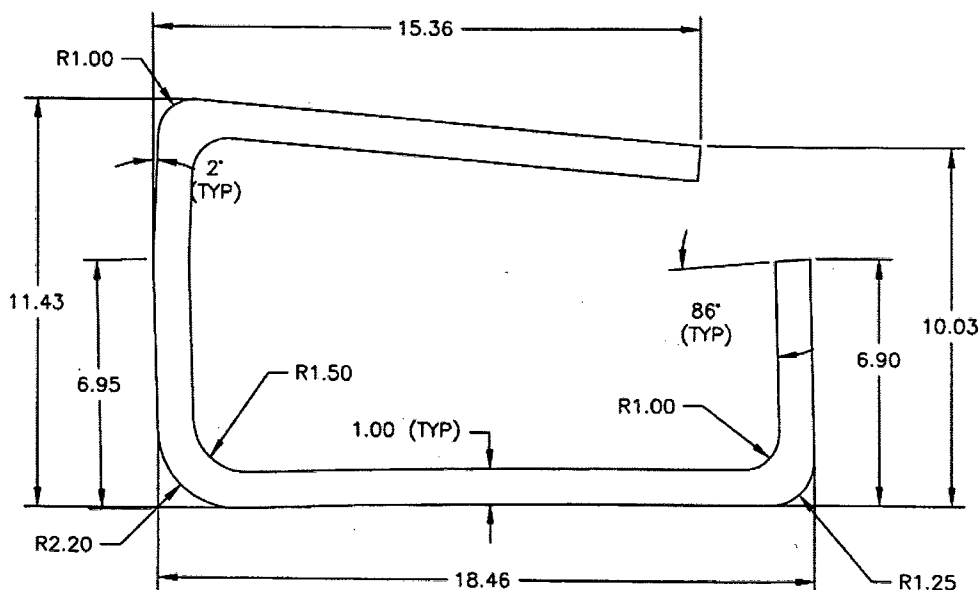
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DART

DESIGN JT	DRAWN BY JT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED JT	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18 JT**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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